

Work Order ID 90637

September-21-12 11:27:05 AM

\*90637\*

Page 1

Item ID: D350-689-011

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Dual High Back Seat

Stop

\*NS2\*

Start Date: 9/21/12 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 10/26/12 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12-09-21 Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
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IIN-D350-689	B	✓ SP
100		0.00
*100*	DOCUMENT CONTROL	
DC	Memo	0.00
Document Control	Photocopy bluefile and create labels per PPP D350-689-011 CHG005	

110	Pick Kit	0.00
*110*	Memo	0.00
Packaging		
Packaging		

120	QC4- 100% Inspect kits for completeness	0.00
*120*	Memo	0.00
QC		
Quality Control		

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS								
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>						
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>						
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>						
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>							
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector				
Doc/Data													
Equip/Tooling													
Operator													
Material													
Setup													
Other													
Process													
Supplier													
Training													
Unapproved													
FAULT CATEGORY													
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions						<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <hr/> <hr/> <hr/>		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <hr/> <hr/> <hr/>	

Work Order ID 90637

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Page 2

Item ID: D350-689-011

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Dual High Back Seat

Stop

\*NS2\*

Start Date: 9/21/12 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 10/26/12 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

\*130\*

Packaging

Packaging

0.00

①8 10/11/16 SP

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D350-689-011

Location: 59

PPP Rev:

140

\*140\*

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/11/16 JJ

MF

12-11-16

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____	<b>DISPOSITION</b>	<b>AGAINST DEPARTMENT/PROCESS</b>					
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>		
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>		
	Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

**FAULT CATEGORY**

Landing Gear	General				
Bending	Bend <input type="checkbox"/>	Grain <input type="checkbox"/>	Ovalized <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>	
Centre Not Concentric to O/S	BOM/Route <input type="checkbox"/>	Hardware <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>	
Cracks	Broken/Damaged <input type="checkbox"/>	Inspection Incomplete <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Weld <input type="checkbox"/>	
Crushed/Crimped.	Burrs <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>	
Cuffs	Contamination <input type="checkbox"/>	Maintenance <input type="checkbox"/>	Part Moved <input type="checkbox"/>		
Heat Treat	Countersink <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>		
Inspection Strip in Tube	Cut Too Short <input type="checkbox"/>	Misread <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>	
Ripples in Bend	Drill Holes <input type="checkbox"/>	Offset <input type="checkbox"/>			
Torque Waves in Extrusion	Drawing <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>			
Turning Sequence	Finish <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>			
Wave/Twist in Tube	Folio <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>			

# Picklist Print

September-21-12 11:27:05 AM

Page 1

Work Order ID: 90637

Parent Item: D350-689-011

Start Date: 9/21/12

Required Date: 10/26/12

Parent Item Name: Dual High Back Seat

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B03.05.09Reformat; Modify Step 1KJ/RF IPP Rev:C chg003 per DSI 9498 DD  
10.02.11 verified by:JLM IPP REV:D 11.11.24 AS PER ECN11-674 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-689-013 Floor Provisions	467W4	Manufactured	No			110	Each	2.0000	1	1	B885Y3 SP		
							<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
							FG010		2				
							87666		2				
D350-689-041 Dual High Back Seat Ass'y		Manufactured	No			110	Each	0.0000	1	1	B88384 SP.		
D3018-1 Seat Cushion		Manufactured	No			110	Each	6.0000	1	SP			
							<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
							ST420A		2				
							77117		2				
							ST424		4				
							88355		4				
D3019-1 Seat Cushion		Manufactured	No			110	Each	6.0000	1	1	SP/12-11-13		
							<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
							ST420A		2				
							77118		2				
							ST425		4				
							88418		4				

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____		Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
NCR No. _____		Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
		Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
		Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									
FAULT CATEGORY									
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions					
				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other					

REFERENCE ONLY

#### 4. WEIGHT AND BALANCE

The following weight and balance information is for the Dart Dual High Back Seat Installation. The weight and balance of the parts that are removed from the aircraft to perform this installation are the responsibility of the installer.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-689-011 Dual High Back Seat Installation, Fwd Position	27.6 lb 12.5 kg	-18.2 in -0.46 m	-502 in-lb -5.8 m-kg	60.7 in 1.54 m	1675 in-lb 19.3 m-kg
D350-689-013 Floor Provisions Kit, Fwd Position	2.0 lb 0.9 kg	-18.2 in -0.46 m	-36 in-lb -0.4 m-kg	60.7 in 1.54 m	121 in-lb 1.4 m-kg
D350-689-011 Dual High Back Seat Installation, Aft Position	28.1 lb 12.7 kg	-18.2 in -0.46 m	-511 in-lb -5.8 m-kg	63.7 in 1.62 m	1790 in-lb 20.57 m-kg
D350-689-013 Floor Provisions Kit, Aft Position	3.1 lb 1.4 kg	-18.2 in -0.46 m	-56 in-lb -0.6 m-kg	62.2 in 1.58 m	193 in-lb 2.2 m-kg
D350-689-015 Seat Modification Kit	1.0 lb 0.5 kg	-17.2 in -0.44 m	-17 in-lb -0.22 m-kg	60.7 in 1.54 m	61 in-lb 0.77 m-kg
D350-689-017 Shoulder Harness, Fwd Position	4.4 lb 2.00 kg	-18.2 in -0.46 m	-80.1 in-lb -0.92 m-kg	60.7 in 1.54 m	267 in-lb 3.08 m-kg
D350-689-017 Shoulder Harness, Aft Position	4.4 lb 2.00 kg	-18.2 in -0.46 m	-80.1 in-lb -0.92 m-kg	64.7 in 1.64 m	285 in-lb 3.28 m-kg
D350-689-019 Control Guard, Fwd Position	0.5 lb 0.23 kg	-9.0 in -0.23 m	-4.5 in-lb -0.05 m-kg	60.7 in 1.54 m	30 in-lb 0.35 m-kg
D350-689-019 Control Guard, Aft Position	0.5 lb 0.23 kg	-9.0 in -0.23 m	-4.5 in-lb -0.05 m-kg	64.7 in 1.64 m	32 in-lb 0.38 m-kg
D350-689-021 Dual High Seat Back Installation, LH Fwd Position	29.2 lb 13.2 kg	-18.2 in -0.46 m	-531 in-lb -6.1 m-kg	60.7 in 1.54 m	1772 in-lb 20.3 m-kg
D350-689-021 Dual High Seat Back Installation, LH Aft Position	29.2 lb 13.2 kg	-18.2 in -0.46 m	-531 in-lb -6.1 m-kg	64.7 in 1.64 m	1889 in-lb 21.6 m-kg
D350-689-023 Energy Attenuating Floor Provisions Kit	2.5 lb 1.1 kg	-18.2 in -0.46 m	-46 in-lb -0.5 m-kg	62.2 in 1.58 m	156 in-lb 1.7 m-kg

#### 5. PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Qty -041	Qty -043	Part Number	Description
X									D350-689-011	DUAL HIGH BACK SEAT INSTALLATION, LH
1	X								D350-689-013	-FLOOR PROVISIONS KIT
	X								D350-689-015	SEAT MODIFICATION KIT
		X							D350-689-017	SHOULDER HARNESS KIT
		X							D350-689-019	CONTROL GUARD KIT
			X						D350-689-021	DUAL HIGH BACK SEAT INSTALLATION, LH
				1	X				D350-689-023	ENERGY ATTENUATING FLOOR PROVISIONS KIT
1							X		D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
					1			X	D350-689-043	DUAL HIGH BACK SEAT ASSEMBLY
							2	2	D3016-041	SEAT FRAME ASSEMBLY
							1	1	D3017-041	BACK FRAME ASSEMBLY
1								1	D3018-1	SEAT CUSHION
1								1	D3019-1	BACK CUSHION
							1	1	D3021-041	TUBE ASSEMBLY
							1	1	D3022-1	SEAT PAN
							1	1	D3023-1	BACK PANEL
							3	3	D3024-1	SPACER
1								1	D3025-1	BEAM

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Revision: B  
 Date: 11.07.22

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Qty -041	Qty -043	Part Number	Description
11	1					1			D3026-1	CHANNEL
11	1								D3027-1	CLIP
11	1								D3027-3	CLIP
11	1								D3027-5	CLIP
11	4					4			D3027-7	CLIP
11							4		D3028-1	STUD
11		2					2		D3029-1	SPRING
11		2					2		D3030-1	LOCK
11							2	2	D3031-1	LOOP
11	1								D3032-1	SPACER
11	2	1							D3033-1	SEAT TRACK
11		4							D3059-1	STUD
11		4							D3060-1	BUSHING
11		4							D3061-1	RADIUS BLOCK
11			1						D3084-3	STRUT
11	1								D3234-1	DOUBLER
11	1					1			D3234-3	DOUBLER
11	2								D3234-5	SPACER
11							2		D3808-041	SEAT RAIL ASSEMBLY
11							4		D3809-1	SLIDING BLOCK
11						1			D3811-041	SEAT TRACK ASSEMBLY
11		2							D4071-041	SHOULDER HARDNESS ASSY
11							3	3	AN3-12A	BOLT
11			1						AN4-12A	BOLT
11			1						AN4-20A	BOLT
11		2							AN5-4A	BOLT
11						40	40		MS20600AD4W2	RIVET
11							6	6	MS20600AD4W3	RIVET
11						9	17	17	MS21042L3	NUT (OR MS21042-3)
11			2				6	6	MS21042L4	NUT (OR MS21042-4)
11		4	2						MS21042L5	NUT (OR MS21042-5)
11	12	4							MS21059L3	NUTPLATE
11							4	4	MS24693-S272	SCREW
11	2	1							MS24693-S273	SCREW
11							8		MS24694-S3	SCREW
11						9			MS24694-S50	SCREW
11								4	MS24694-S148	SCREW
11	6	3							MS27039-1-10	SCREW
11							4	4	MS27039-1-17	SCREW
11							6	6	MS27039-1-19	SCREW
11							6	6	MS27039-4-21	SCREW
11	6	3					17	17	NAS1149D0332J	WASHER (OR AN960JD10L)
11						9			NAS1149D0363J	WASHER (OR AN960JD10)
11			8						NAS1149D0416J	WASHER (OR AN960JD416L)
11							6	6	NAS1149D0432J	WASHER (OR AN960JD416)
11		4							NAS1149D0516J	WASHER (OR AN960JD516L)
11		4							NAS1149D0563J	WASHER (OR AN960JD516)
11			2						NAS43DD4-46N	SPACER

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Revision: B  
 Date: 11.07.22